

Work Order ID 85087

85087

Page 1

Friday, June 01, 2012 3:27:00 PM

Item ID: PB67-43001-01

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 12-06-20 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

B67-43001-01

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg and notes on dwg B67-43001 and use 242 threadlock
Blue
A/R shown on dwg PB67-43001 page 2.
242 THREADLOCK Blue batch:
A/R touch up paint with sandflex green
batch: *m112961*

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8/12/04/29

(XL)

1 0
12.06.27
12.06.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: PB67-43001-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

CK 12/7/10
MF 12-07-09

W/O:		WORK ORDER CHANGES					
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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec
EC verified by:DD
IPP RevC 10.09.24 per RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	82.0000	8	8		122089	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		82							
				115827		82							
30345T22 8" LANYARD		Purchased	No			100	Each	18.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		18							
				112853		18							
30345T24 LANYARDS		Purchased	No			100	Each	42.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		42							
				112853		42							
AN4-10A Bolt		Purchased	No			100	Each	81.0000	2	2		12/6/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		81							
				117619		31							
				121666		50							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No

100 Each 1,261.0000 2 2

Bolt

Location

Loc Qty

Loc Code

ST357

1261

119449

33

120187

19

120422

2

120770

207

121652

1000

AN4-15A

Purchased

No

100 Each 527.0000 4 4

Bolt

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

327

118706

3

120422

24

121444

100

121541

200

AN6-11A

Purchased

No

100 Each 71.0000 2 2

BOLT

Location

Loc Qty

Loc Code

ST341

71

111177

21

114437

50

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

AN6-20A
Bolt

Purchased

No

100 Each 51.0000

2 2

Location

Loc Qty

Loc Code

ST341

50

118706

50

ST342

1

114941

1

118706

0

AN8-13A
BOLT

Purchased

No

100 Each 14.0000

2 2

Location

Loc Qty

Loc Code

ST343

14

110915

14

BSP43
RIVET

Purchased

No

100 Each 55.0000

4 4

Location

Loc Qty

Loc Code

ST284

55

110704

50

111127

5

CR3213-4-05
cherry rivet

Purchased

No

100 Each 141.0000

2 2

Location

Loc Qty

Loc Code

ST331

141

108473

41

108991

100

D3445-041
Belt Assembly

Manufactured

No

100 Each 4.0000

1

Location

Loc Qty

Loc Code

ST440

4

52615

4

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

D3447-3
Square Spacer

Manufactured No

100 Each 5.0000

2 2

Location

Loc Qty

Loc Code

ST440

5

~~41351~~
58012

1

4

D3447-7
Clevis

Manufactured No

100 Each 6.0000

2 2

Location

Loc Qty

Loc Code

ST440

6

52665

6

D3447-9
Swing Arm

Manufactured No

100 Each 8.0000

2 2

Location

Loc Qty

Loc Code

ST440

8

~~57745~~
62127

4

4

D3451-041
Handle and Lock-Down Assembly

Manufactured No

100 Each 1.0000

1 1

Location

Loc Qty

Loc Code

ST440

1

52565

1

D3451-047
Handle and Lock-Down Assembly

Manufactured No

100 Each 1.0000

1 1

Location

Loc Qty

Loc Code

ST442

1

52568

1

D3922-1
Clip

Manufactured No

100 Each 42.0000

2 2

Location

Loc Qty

Loc Code

ST070

42

66852

42

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS17984-C408
PIN, QUICK RELEASE

Purchased

No

100 Each 8.0000

2

2

Location

Loc Qty

Loc Code

ST314

8

112940

8

MS17984-C418

Purchased

No

100 Each 20.0000

2

Location

Loc Qty

Loc Code

ST315

20

114416

3

114523

17

MS21042L3

Purchased

No

100 Each 2.195 0000

2

Nut

Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

MS21042L4

Purchased

No

100 Each 3,910.0000

8

8

Nut

Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L6 Purchased No

100 Each 648.0000

4

4

Nut

Location

Loc Qty

Loc Code

ST300

648

117677

25

118384

3

118927

48

119075

372

120308

200

MS27039-1-04

Purchased No

100 Each 411.0000

2

2

SCREW

Location

Loc Qty

Loc Code

ST291

411

119638

3

120142

100

120308

34

120910

74

121476

200

MS27039-1-21

Purchased No

100 Each 200.0000

2

2

SCREW

Location

Loc Qty

Loc Code

ST291

100

115935

100

ST292

100

115935

100

MS51859-6

Purchased No

100 Each 108.0000

4

WASHER

Location

Loc Qty

Loc Code

ST296

108

111279

8

112940

100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS51859-7 Purchased No

Each 22.0000

4

Washer

Location

Loc Qty

Loc Code

ST296

22

111193

12

120518

10

MS51859-8 Purchased No

100 Each 46.0000

8

8

WASHER

Location

Loc Qty

Loc Code

ST296

46

112940

46

NAS1149DN632J

Purchased No

100 Each 200.0000

6

6

Washer

Location

Loc Qty

Loc Code

ST298

200

118428

200

NAS1149F0316P

Purchased No

100 Each 245.0000

4

WASHER

Location

Loc Qty

Loc Code

ST275

245

112940

45

113237

100

113644

100

NAS1149F0432P

Purchased No

100 Each 792.0000

16

16

Washer

Location

Loc Qty

Loc Code

ST275

792

121350

792

NAS1149F0632P

Purchased No

100 Each 465.0000

8

8

WASHER

Location

Loc Qty

Loc Code

ST275

465

18057

465

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0832P

Purchased

No

100

Each

248.0000

2

2

WASHER

Location

Loc Qty

Loc Code

ST275

248

18057

248

NAS43DD3-68

Purchased

No

100

Each

36.0000

2

2

SPACER

Location

Loc Qty

Loc Code

ST278

1

112410

1

ST279

35

120142

35

~~PB67-43001-09~~
PB67-43001-07

Manufactured

No

100

Each

0.0000

1

1

Fwd Blade Fold Assembly Weldment

PB67-43001-11

Manufactured

No

100

Each

0.0000

1

1

Fwf Adjustable Blade Support Assembly

PB67-43001-15

Manufactured

No

100

Each

0.0000

1

1

Fwf Adjustable Blade Support Assembly

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

1

PB67-43001-21

PB67-43001-23

Manufactured

No

100

Each

0.0000

1

1

PB67-43001-23

PB67-43001-261

Manufactured

No

100

Each

12.0000

2

2

Lever Arm

Location

Loc Qty

Loc Code

ST432

12

62182

12

PB67-43001-265

Manufactured

No

100

Each

11.0000

4

Deltin Bushing

Location

Loc Qty

Loc Code

ST438

11

40056

11

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-299

Manufactured

No

100

Each

17.0000

2

Bushing

Location

Loc Qty

Loc Code

ST439A

17

44969

17

PB67-43001-45

Manufactured

No

100

Each

0.0000

1

Longitudinal Support

PB67-43001-51

Manufactured

No

100

Each

0.0000

1

Long T-Handle Assembly

2
B85112
B851135
12-6-25

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W/O:		WORK ORDER CHANGES					
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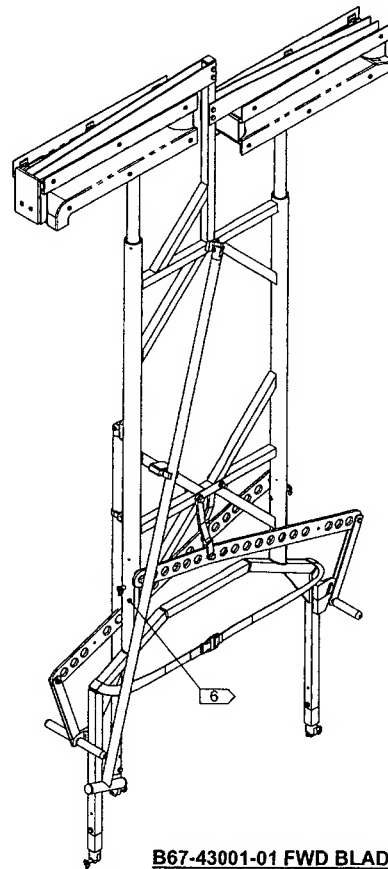
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ITEM	QTY. -01	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG T-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELTRIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN6-20A	BOLT
25	2	AN8-13A	BOLT
26	4	BSP43	RIVET
27	2	CR3213-4-C5	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS51859-6	NYLON WASHER
37	4	MS51859-7	NYLON WASHER
38	8	MS51859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242XX	LOCTITE 242 THREADLOCKER, BLUE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\phi 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING $1/8"$ DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING).
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOW. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

RELEASED
2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011	VS	10.06.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	VS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-01** REV. C
SHEET 1 OF 2
TITLE **FWD BLADE FOLD ASSY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries